

delrin ϕ 3/4

Work Order ID 137917

137917

Page 1

Wednesday, October 14, 2015 3:04:37 PM

Item ID: D3917-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Washer

Start Date: 10/29/2015 Start Qty: 24.00

24

Cust Item ID:

Required Date: 11/3/2015 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: OCT 15 2015

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3917

A

100

0.01

100

Hardinge

Memo

0.01

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA876 & DWG

FOLIO REV: AA

DWG REV: B

DEBURR

51 ϕ JHL 2015-10-26

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

51 ϕ JHL 2015-10-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : ☐			
Misidentified	☐	Past Due	☐				

Work Order ID 137917

137917

Page 2

Wednesday, October 14, 2015 3:04:37 PM

Item ID: D3917-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Washer
Start Date: 10/29/2015 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 11/3/2015 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						51	Ø		DAS 40 9-89
QC	Memo	0.01							15/16/26
Quality Control									
130	Identify as per dwg & Stock Location: <u>5108</u>	0.00							
130						51			DAS 27 9-89
Packaging	Memo	0.00							OCT 27 2015
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140						ML5			OCT 27 2015
QC	Memo	0.04							
Quality Control									

ML5 OCT 27 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Picklist Print

Wednesday, October 14, 2015 3:04:36 PM

Page 1

Work Order ID: 137917

137917

Parent Item: D3917-3

D3917-3

Parent Item Name: Washer

Start Date: 10/29/2015

Required Date: 11/3/2015

Start Qty: 24.00

Required Qty: 24.00

Comments: Ipp Rev:A New Issue 09-12-02 JLM Verified by:DD
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750		Purchased		No		100	f	50.0410	0.02	0.505262			

MDFI RINR0 750

Delrin Round Bar 0.75" color: black

Location	Loc Qty	Loc Code
MAT038	48.085	
<u>m131967</u>	48.085	
MAT039	1.956	
m127442	0.16	
m130432	1.796	

1.053 ~~1.053~~ OFC 2015-10-26

DQA: _____ Date: _____

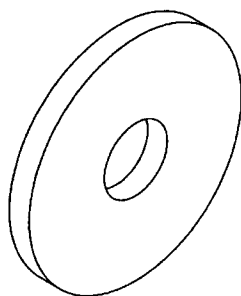


WORK ORDER NON-CONFORMANCE / UPDATE

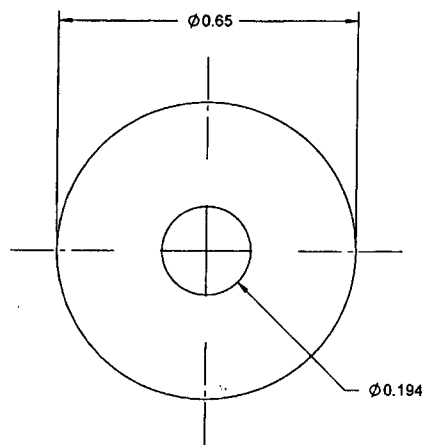
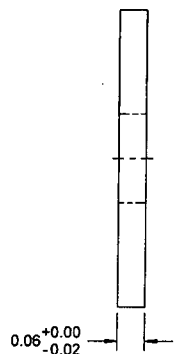
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Work Order update only ☐

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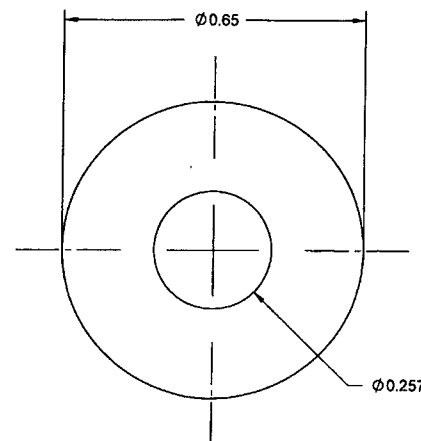
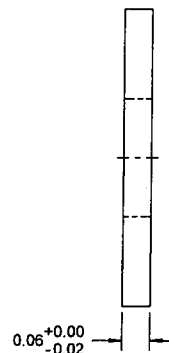


ISO VIEW



D3917-1 WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 137917 MJS
15-10-15



D3917-3 WASHER

RELEASED
2010-02-16
MJS

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, COLOR BLACK
REF DART SPEC M-DELRIN-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: < 0.01 lbs

A		NEW ISSUE		JPH	10.01.29
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D3917	SHEET 1 OF 1		
APPROVED		TITLE	SCALE		
DE APPR.		WASHER (350 BASKET)	NTS		
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD			
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